

Work Order ID 69399

Tuesday, May 10, 2011 2:54:44 PM



Page 1

Item ID:	D3562-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly, RH					
Start Date:	5/10/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	5/16/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-05-10	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3562	Rev E								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622 extrusion as per Dwg D3562 2-Debur and bevel ends for welding								

11.05.18

4 0

110		0.00							
	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control									

11.05.18

120		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

4x 0 m.t 11/06/02
RHX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

R 11-06-10

4

0

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- Drill Rivet holes as per dwg D3562. Touch up alodine
2- Rivet legs using Magnabond as per dwg D3562.
*****Ensure to wipe off any excess magnabond *****
A/R Magnabond 6398 Batch: 1117270

R 11-06-10

4

0

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11-06-13

4
RH

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Large Fab	Large Fab	0.00				4	0		
Large Fab	Memo 1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/RAluminum Rod <i>M114703</i> 2-Grind end cap welds flush as per Dwg D3562	0.00							
170 QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							
180 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 RH of 11/06/15

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:50
32001
8:20

0.00

210

Wing Walk as per dwg QSI005 4.4 Batch M117863

0.00



HandFinish

Memo

0.00

Hand Finishing

4 RH of 11/06/15

M116964

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 0 11-6-15

230

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

6-A 2X
w/o
69397 (2X)

4/6/15 (4)

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15 (4)

11-6-16

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Picklist Print

Page 1

Tuesday, May 10, 2011 2:54:50 PM

Work Order ID: 69399



Parent Item: D3562-042



Parent Item Name: Step Assembly, RH

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C		Manufactured	No			100	Each	100.0000	1	4			
Step Extrusion													

Location	Loc Qty	Loc Code
HALL	9	
64409	9	
WA	91	
46910	2	
66970	89	

D2734		Manufactured	No			140	Each	35.0000	2	8			
Step End Plate													

Location	Loc Qty	Loc Code
WA015	35	
66143	35	

D3560-042		Manufactured	No			140	Each	3.0000	1	4			
Arm Weldment													

Location	Loc Qty	Loc Code
WA013	3	
48386	3	

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D3562-042


Parent Item Name: Step Assembly, RH


Start Date: 5/10/2011



Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

D3560-044 Manufactured No 140 Each 4.0000 1 4  11.06.10

 Arm Weldment

Location	Loc Qty	Loc Code
WA013 <u>369617</u>	4	<u>2</u>
<u>48388</u>	4	<u>2</u>
MS20600-AD4W5 Purchased No 160 Each 543.0000 32 128  <u>11.06.10</u>		
 Blind Rivet		

Location	Loc Qty	Loc Code
ST321 <u>117885</u>	537	<u>128</u>
114382	237	
116289	100	
117505	200	
WA018	6	
111477	6	

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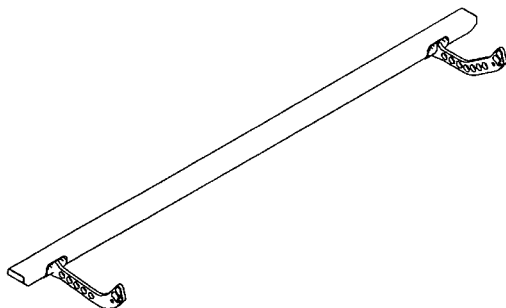
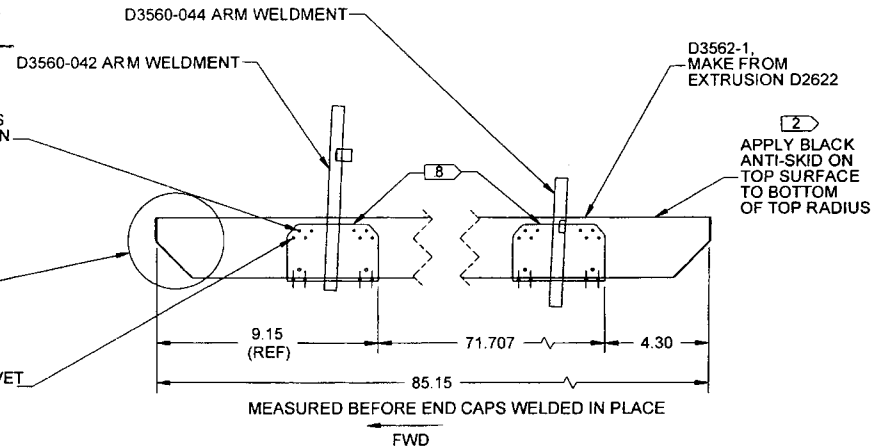
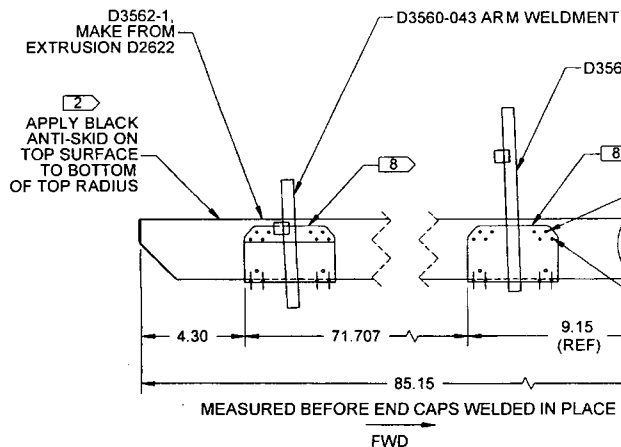
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT 4

WITHOUT NOTICE
WORK ORDER
NO. 09399

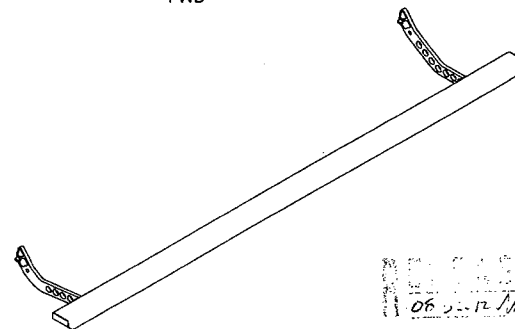
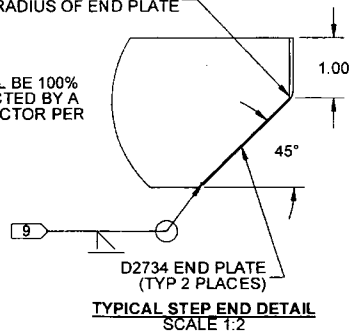
PH-05-13C



D3562-041 LH STEP ASSEMBLY

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D3562-042 RH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>gp</i>		
DRAWN	<i>gy</i>		
CHECKED	<i>le</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.01.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3562**
TITLE **STEP ASSEMBLY**
REV. E
SHEET 1 OF 1
SCALE 1:5

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